

Work Order ID 71746

Monday, July 11, 2011 9:09:50 AM



Page 1

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	7/11/2011	Start Qty:	2.00			
Required Date:	7/15/2011	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	11-07-11	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3836	Rev A								

100		0.00							
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	Large Fab								
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Large Fab	Memo	0.00							
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Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836								
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2- remove identification markings

3- deburr

S40 11-07-20

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836
A/R ER316 S.S. Rod Batch: M115788

6- grind weld flush where indicated on dwg

130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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QC	Memo	0.00							
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Quality Control									
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2

11.07.21 2

2 8 8E 11/07/25
11-07-25



Work Order ID 71746







Monday, July 11, 2011 9:09:50 AM



Page 2

Item ID: D3836-041 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly (Basket Lid, LH) Stop 
Start Date: 7/11/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/15/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					11	07	21-2
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WAS</u> Memo	0.00 0.00					11.07	25	2
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/7/25	

11-07-25
2

Picklist Print

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Page 1

Work Order ID: 71746

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/11/2011

Required Date: 7/15/2011

Start Qty: 2.00

Required Qty: 2.00



Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3		Manufactured	No			100	Each	14.0000	1	2			
													
Spacer Bushing													

Location Loc Qty Loc Code

WA 14
70884 14

M304TS0.750W.065		Purchased	No			100	f	697.9792	1.7808	3.749053			
													
304 SQ Tube .75x.75x.065W													

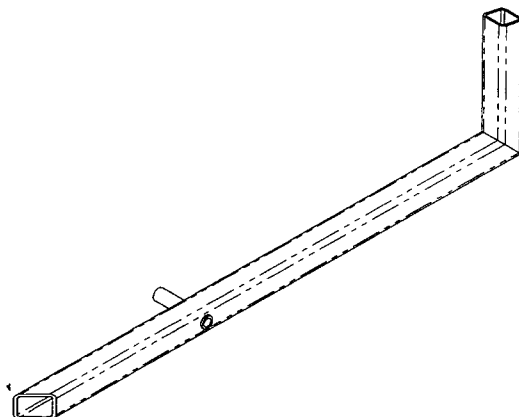
Location Loc Qty Loc Code

MAT018 91.83716
117598 14.13846
117636 77.6987
WA 500
118181 500
WA007 106.1419906
116267 99.549272
116763 6.5927186

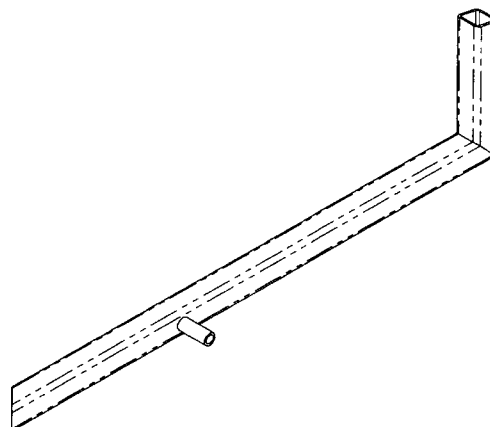
71971 1MB 11/07/21

SAD 11-07-20

3.7491



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71746

08/11-07-11

RELEASED
08/11/11

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.99 lbs EACH
8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<i>AS-3</i>		
MFG. APPR.	<i>JD</i>		
APPROVED	<i>JD</i>		
DE APPR.	<i>JD</i>		
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

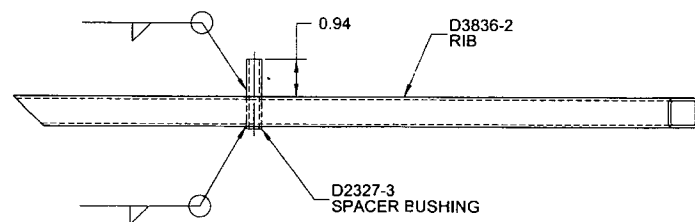
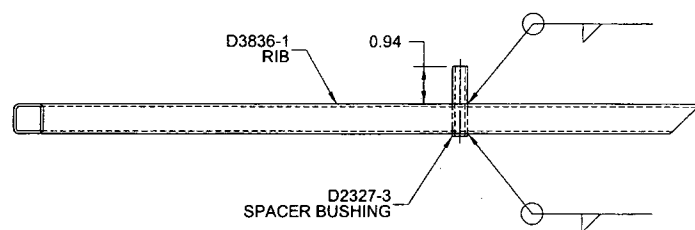
DRAWING NO. **D3836** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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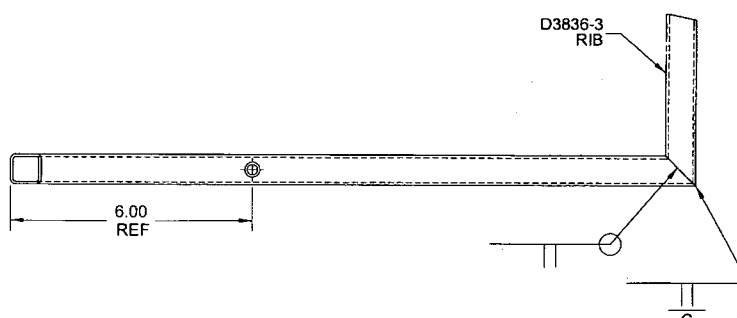
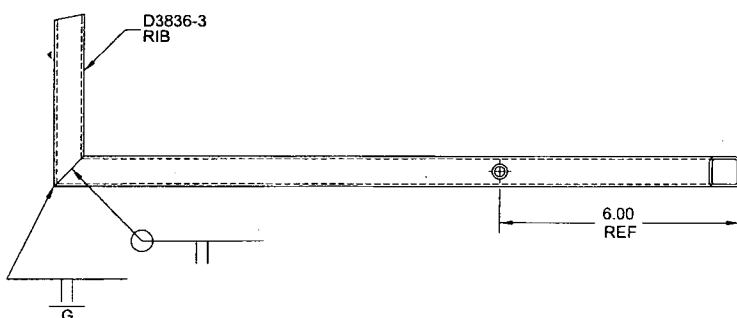
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B

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D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

71244

RELEASED
08/11/18

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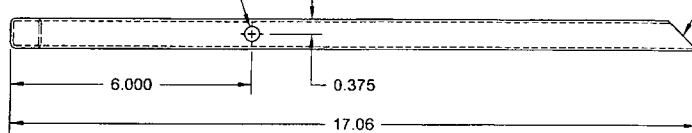
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MFG. APPR.		TITLE	SHEET 2 OF 3
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DE APPR.			NTS
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CHAMFER

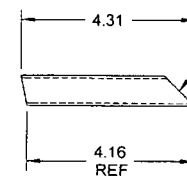


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



0.75 X 45°
CHAMFER

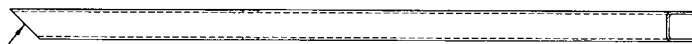
D3836-1 RIB



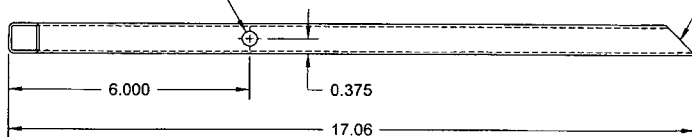
0.75 X 45°
CHAMFER

D3836-3 RIB

0.75 X 45°
CHAMFER

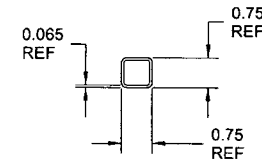


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0.75 X 45°
CHAMFER

D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/87

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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